

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018383**Date Inspected:** 28-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr.Xu Le Fung.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

BAY 10:

OBG Bike path, FCAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 052075, 040533 Perform Flux Core Arc Welding (FCAW) on OBG Bike path plate. Joint identified as BK004A6-026-002, 007. ZPMC QC Identified as Yu Zhi Lai. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2332-Tc-P4-F. For more information see below attached picture number 1.

This QA Inspector observed ZPMC qualified welding personnel identified as 052075, 040533 Perform Flux Core Arc Welding (FCAW) on OBG Bike path plate. Joint identified as BK004A6-026-001, 165. ZPMC QC Identified as Yu Zhi Lai. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F.

OBG Bike Path, Repair welding, FCAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 052075 Perform Flux Core Arc

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Welding (FCAW) on OBG Bike path. Plate identified as BK004A-026, BKPL8A. ZPMC QC Identified as Yu Zhi Lai with Temporary welding repair report WWR-B-WR16921. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-2G (2F) Repair.

### Magnetic Particle Testing:

This QA Inspector observed ZPMC Magnetic Particle Testing Inspector, performed MT on OBG Bike path Bottom cover plate weld. Joint identified as BK004A2-027-018, 016. For more information see below attached picture number 2.

### BAY 11:

#### Tower Lift 6, FCAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 040723, Perform Flux Core Arc Welding (FCAW) on lift 6 assembly plate. Joint identified as ESD1-FFSA6-2-25, 26. ZPMC QC Identified as Libin. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2332-Tc-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 040736, 040704, 040723, 205649, Perform Flux Core Arc Welding (FCAW) on lift 6 assembly plate. Joint identified as ESD1-FFSA6-2-1, 2, 9, 10. ZPMC QC Identified as Libin. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132.

This QA Inspector observed ZPMC qualified welding personnel identified as 053316, Perform Flux Core Arc Welding (FCAW) on lift 6 Assembly Plate. Joint identified as ESD1-FESA6-2-8, 15. ZPMC QC Identified as Libin. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2332-Tc-P4-F.

### OBG Bike path, SMAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 044541 Perform Shielded Metal Arc Welding (SMAW) on OBG Bike path plate. Joint identified as BK005B3-004-100, 101, 102. ZPMC CWI Identified as Yu Dong Ping. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2114.

This QA Inspector observed ZPMC qualified welding personnel identified as 044541 Perform Shielded Metal Arc Welding (SMAW) on OBG Bike path plate. Joint identified as BK005B4-004-100, 101, 102. ZPMC CWI Identified as Yu Dong Ping. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2114.

### BAY 10, Green Tagging

This QA inspector performed Visual Inspection for Green Tagging which were previously tested and accepted by ZPMC Quality Control personnel Mr. Xu Le Feng and ABF QA personnel Mr. Liu Cheng. The members are identified as OBG Bike Path BK004A1-032 (Step 3). The green Tag number is identified as # 13779.

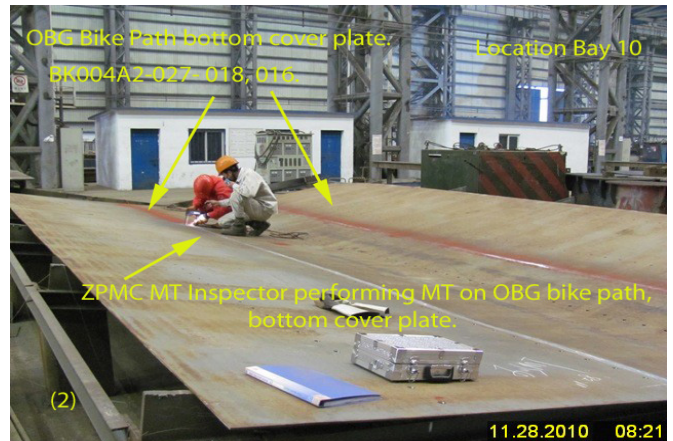
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Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Ho phone : 150002048250, who represents the Office of Structural Materials for your project.

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**Inspected By:** Gaikwad,Shailesh

Quality Assurance Inspector

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**Reviewed By:** Clifford,William

QA Reviewer

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